AMENDMENTS TO THE CLAIMS

Please amend claim 1 and add new claims 4-9 as follows.

1. (Currently Amended) Device for producing castings out of a fusible or dispersible base material, comprising an injection unit from which the at least partially liquefied material can be injected into a mold, wherein the injection unit has an inlet port for feeding the material, and wherein the injection unit has a chamber with two movable walls which are adapted to move either together in the same direction or in opposite directions so to vary a volume of the chamber, wherein the volume of the chamber is reduced to about zero before feeding the material into the chamber, and wherein the two walls forms a cavity,

wherein one of the two walls is movable into the mold;

wherein the one of the two walls that is movable into the mold is configured to partially determine the surface shape of the casting; and

wherein said two movable walls can be located so that a sprue point is displaced into the casting to avoid sprue.

2. (Original) Device according to claim 1, wherein the wall which is movable into the mold is configured as a piston which is supported within a tubular chamber wall so as to be longitudinally movable or is supported so as to be movable toward the chamber to perform a sealing function, and wherein the wall is movable together with a movable mold section of the mold.

3. (Cancelled)

4. (New) Device according to claim 1, wherein the volume of the chamber is reduced to an extent that contact with ambient air is precluded.

5. (New) Device according to claim 1, wherein the volume of the chamber is reduced to a minimum while avoiding direct contact of the two movable walls.

6. (New) A method for producing a casting out of a fusible or dispersible base material, comprising:

feeding the material into a chamber formed with at least two movable walls in an injection unit, wherein the movable walls are adapted to move to vary a volume of the chamber, wherein the volume of the chamber is set to about zero before feeding the material into the chamber and the volume of the chamber increases in proportion to an amount of the material fed into the chamber,

moving the movable walls to a position where one of the movable walls is moved into a mold and configured to partially determine the surface shape of the casting; and

injecting the material into the mold.

7. (New) The method according to claim 6, wherein, prior to the act of feeding, the volume of the chamber is sized such that contact with ambient air is precluded.

8. (New) The method according to claim 6, wherein, prior to the act of feeding, the volume of the chamber is reduced to a minimum while avoiding direct contact of the two movable walls.

9. (New) A method for producing a casting out of a fusible or dispersible base material, comprising:

forming a chamber in an injection unit, wherein the volume of the chamber is a minimum while avoiding direct contact of the two movable walls;

feeding the material into the chamber, wherein the volume of the chamber increases in proportion to an amount of the material fed into the chamber,

moving the material in the chamber to a mold; and

injecting the material into the mold.